



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and identifying the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and making any necessary adjustments.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved for next time.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying open to new ideas and ways of solving problems.

9. The ninth step is to be a good team player. This involves working well with others and helping them to solve their problems.

10. The tenth step is to be a good leader. This involves helping others to solve their problems and leading them to success.

Page 2

[illegible][illegible]

**Stop**

[illegible]

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

**Cust Item ID:**

\_\_\_\_\_

**Customer:**

**Reference:**



**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_



**Insp.  
Stamp**

0.00

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

QC

## Memo

0.00

8/11/30

## Quality Control

0.00

**10**

Brake NC

NC BRAKE

## Memo

0.00

Brake NC

1-Bend as per Dwg D3023□2-form edge of back pan as per dwg D3023 using  
D3017-041 back frame

using  
JB 116513

12

11-673 XI

QC5- Inspect part completeness to step on W/O

0.00

[illegible]

QC

## Memo

0.00

## Quality Control

8 ulas/14

71

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**NOTE:** Date & initial all entries

# Work Order ID 70017

Wednesday, May 25, 2011 12:03:18 PM

Page 3

Item ID: D3023-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Back Panel

Start Date: 5/25/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00

Customer:




Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				1	0	211	u loe l a
160  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 8:30 3200 <input checked="" type="checkbox"/> FINISH TIME: 9:00 <input type="checkbox"/> OVEN TEMPERATURE:	0.00  0.00				1X	0	M-L 11/06/14	
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				1	0	11-6-14	

M 115128

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 70017**

Page 4

Wednesday, May 25, 2011 12:03:18 PM

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: *G.A*

0.00



Packaging

Memo

*w/o  
70006*

0.00

Packaging

*E.S. 11/06/14*

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/06/14**MF  
11-06-14*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

Wednesday, May 25, 2011 12:03:15 PM

Page 1

Work Order ID: 70017

Parent Item: D3023-1

Parent Item Name: Back Panel



Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.01.23 Revised NG  
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	39.9000	2.8777	3.029158			



2024-T3 .032 sheet



1311-5-30

Location

Loc Qty

Loc Code

MAT22

39.9

111699

0.5

113189

39.4

113189

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

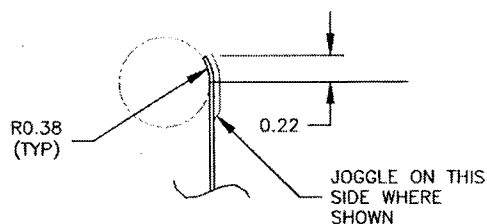
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

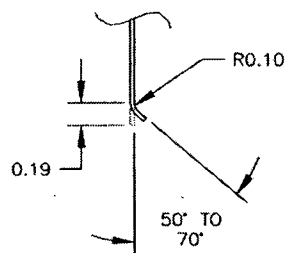
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

SECTION A-A  
SCALE 1:1  
(TYPICAL, EXCEPT WHERE SHOWN)



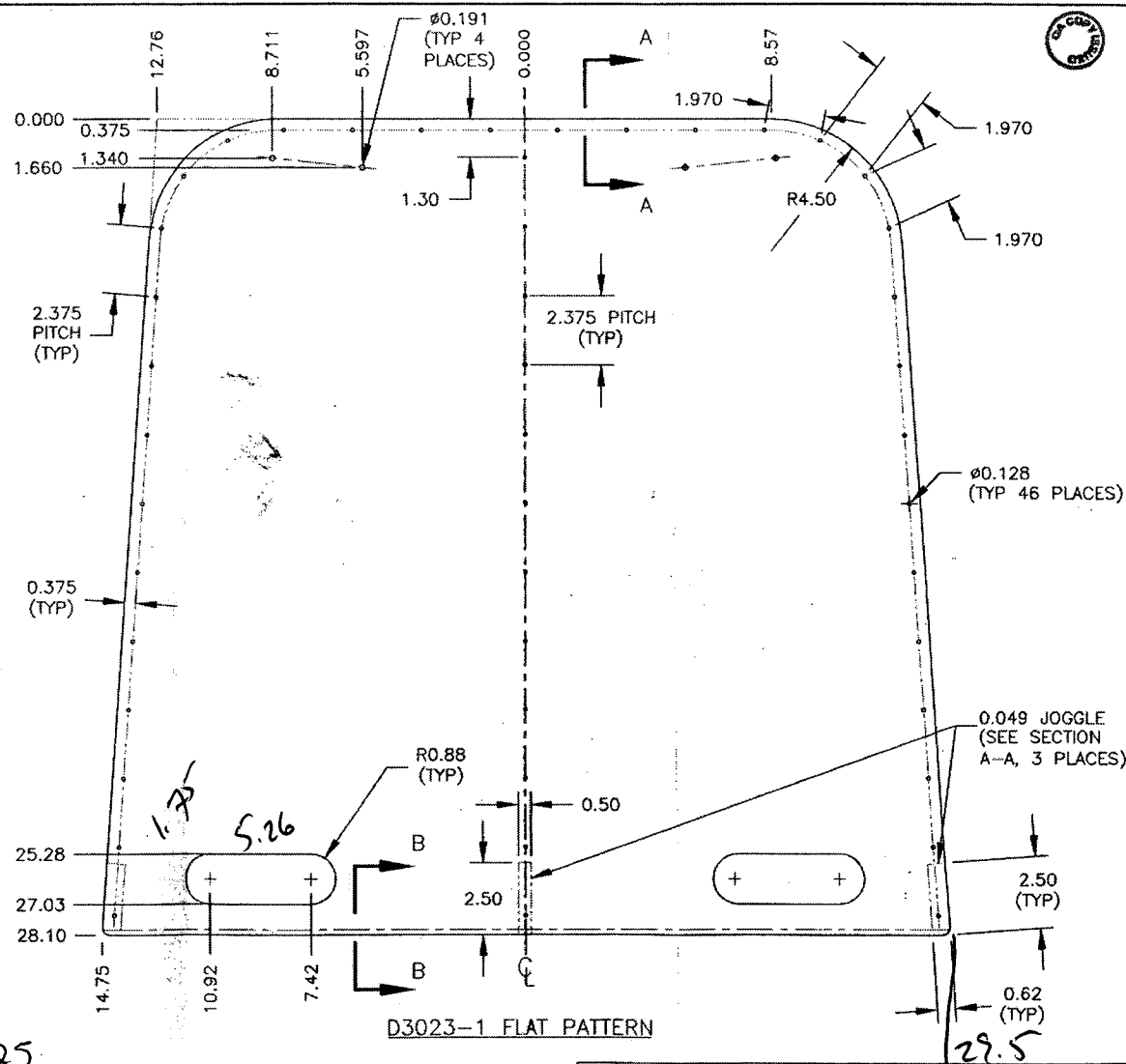
SECTION B-B  
SCALE 1:1  
(BOTTOM EDGE ONLY)



RELEASED  
9.06.07

D3023-1 BEND DETAIL

CL 11/05/25  
W/0: 70017



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

COPYRIGHT © 2001 BY DART AEROSPACE LTD.		01.05.18		NEW ISSUE	
DESIGN	CL	DRAWN BY	CL	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA	
CHECKED	CL	APPROVED	CL		
DATE	01.05.18	DRAWING NO.	D3023	TITLE	BACK PANEL
				REV. A	SHEET 1 OF 1
				SCALE	1:1

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	70017
<b>Description:</b> Back Panel		<b>Part Number:</b>	D3023-1
<b>Inspection Dwg:</b> D3023	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131	✓		V HB02	
Ø0.191	+0.005/-0.001	.191	✓		V	
1.660	+/-0.010	1.659	✓		V	
0.375	+/-0.010	.378	✓		V	
1.340	+/-0.010	1.342	✓		V	
2.375	+/-0.010	2.374	✓		V	
0.375	+/-0.010	.376	✓		V	
25.28	+/-0.030	25.28	✓		T HB01	
27.03	+/-0.030	27.03	✓		T	
28.10	+/-0.030	28.10	✓		T	
1.30	+/-0.030	1.300	✓		V	
2.375	+/-0.010	2.377	✓		V	
8.711	+/-0.010	8.710	✓		PRO W302	
5.597	+/-0.010	5.595	✓		V	
8.57	+/-0.030	8.57	✓		P	
1.970	+/-0.010	1.970	✓		V	
7.42	+/-0.030	7.42	✓		V	
10.92	+/-0.030	10.92	✓		P	
14.75	+/-0.030	14.75	✓		T	

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-5-30	<b>Date:</b> 11/05/30	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC [Signature]	[Signature]

